

Work Order ID 152895

152895

Page 1

Monday, November 07, 2016 4:06:11 PM

Item ID: D3594-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 11/2/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 11/7/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: NOV 08 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS 46 9-89		
D3594	C							16/11/14	
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg D3594								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

3 DAS 46 9-89 16/11/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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NOV 23 2016

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NS1

Stop *NS2*

3

3

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

0.02

XB



2016/11/23

BETB.

0.00

0.00

3

NOV 23 2016

Identify as per dwg & Stock Location: 81 099 0.00

0.00

34

NOV 25 2016

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 4

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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89 NOV 25 2016

DQA: _____ Date: _____



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Picklist Print

Monday, November 07, 2016 4:06:11 PM

Page 1
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Work Order ID: 152895

152895

Parent Item: D3594-5

D3594-5

Parent Item Name: Doubler

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev :A New Issue 08.07.07 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	118.3400	0.055	0.173684			
M6061T6S 080													
6061-T6 .080 Sheet													

DAS
46
9-89

16/11/14

Location

Loc Qty

Loc Code

MAT020

118.34

134217

9.1

m132772

4.3

m133587

7.7

m133828

2.6

m134551

7

m134830

19.9

m135147

18.07

m135559

12.87

m135861

36.8

0.16

DQA: _____ Date: _____

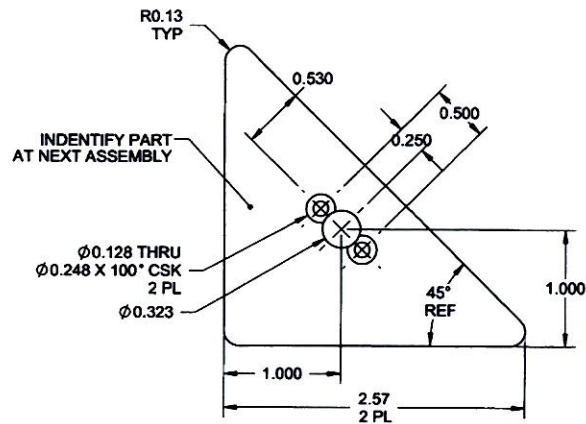


WORK ORDER NON-CONFORMANCE / UPDATE

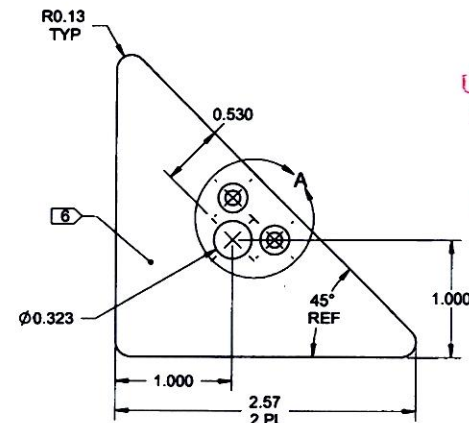
QA Closed: _____ Date: _____

Work Order update only ☐

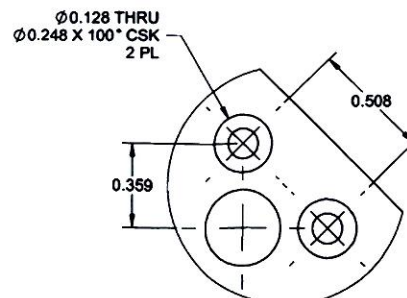
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER



DETAIL A
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -5 ONLY: IDENTIFY PER DART QSI 044
- 7) WEIGHT -1/-5: 0.03 lbs

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WITHOUT NOTICE
WORK ORDER

NO. 152895 MLT

16-11-08

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	16.05.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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